

InStruc® PA66GF13MR

Americhem - Polyamide 66

General Information
Product Description

13% GLASS FIBER REINFORCED NYLON 6/6 WITH MOLD RELEASE

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Features	• Filled	• Good Mold Release	• High Strength
	• Good Dimensional Stability	• High Stiffness	
Uses	• Automotive Applications	• Engineering Parts	• Industrial Parts
	• Closures	• Household Goods	• Office Automation Equipment
	• Consumer Applications	• Housings	• Outdoor Applications
	• Electrical/Electronic Applications	• Industrial Applications	• Window & Door Components
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow	6.0E-3 to 8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Mechanical			
Tensile Modulus	900000	psi	ASTM D638
Tensile Strength	17500	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 4.0	%	ASTM D638
Flexural Modulus	700000	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	0.90	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	9.0	ft·lb/in	ASTM D4812
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	470	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	175	°F
Drying Time	4.0	hr
Processing (Melt) Temp	500 to 575	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

